

Work Order ID 78368

78368

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Friday, January 06, 2012 10:58:28 AM

Item ID: D350-578-011

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Bearpaw

Stop ***NS2***
Ship Monday

Start Date: 1/6/2012 Start Qty: 3.00 ***3***

Cust Item ID:

Required Date: 1/9/2012 Req'd Qty: 3.00 ***3***

Customer:

Reference:

Approvals: Process Plan: *12-01-06* Date: _____

Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____

SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D2432	Rev F3
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100		0.00
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100

DOCUMENT CONTROL

DC	Memo	0.00
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Document Control Photocopy bluefile and create labels per PPP D350-578-011 CHG005

8/2/01/09

MLT 12-01-06

160	Pick Kit	0.00
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160

Packaging	Memo	0.00
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Packaging

SP 12-01-06

170	QC4- 100% Inspect kits for completeness	0.00
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170

QC	Memo	0.00
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Quality Control

8/2/01/09

(x3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D350-578-011 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Bearpaw
Start Date: 1/6/2012 Start Qty: 3.00 ***3*** Cust Item ID:
Required Date: 1/9/2012 Req'd Qty: 3.00 ***3*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	Packaging	0.00							
180									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D350-578-011 Location: <u>12/1/9</u>								
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									

12/1/9 7/3

12/01/9
MF
12-01-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 78368

Parent Item: D350-578-011

Parent Item Name: Bearpaw

Start Date: 1/6/2012

Required Date: 1/9/2012

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP Rev:A New Issue 07-01-02 JLM
IPP Rev:B 08-01-09 Added Step 2 JLM Verified By:EC
IPP Rev:C 08-10-15 New Manufacturing Method JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN4-17A Bolt		Purchased	No			160	Each	456.0000	12	36			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST359		456							
				118628		56				36 x			
				118983		300							
				119798		100							
D2182B Rubber Cushion		Manufactured	No			160	f	538.3342	2.5	7.5			
Cut qty 6 at 5.00" long				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST410		538.33417							
				66063		53.94817				7.5			
				73932		484.386							
D2274 Radius Block		Manufactured	No			160	Each	185.0000	12	36			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST007		185							
				73389		1							
				76104		102				36			
				77034		82							
D2432 206 (24") Bearpaw		Manufactured	No			160	Each	6.0000	2	6			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST495		6							
				68672		0							
				73981		6							

73981 12/1/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 78368

Parent Item: D350-578-011

Parent Item Name: Bearpaw

Start Date: 1/6/2012

Required Date: 1/9/2012

Start Qty: 3.00

Required Qty: 3.00

D2438

Clamp

Manufactured No

160 Each 115.0000

6 18 SP.

Location

Loc Qty

Loc Code

ST456

115

69737

84

73400

31

5x
Bx.

D2529

Washer

Manufactured No

160 Each 202.0000

12 36

Location

Loc Qty

Loc Code

ST010

202

71161

6

76086

196

6x
30x
SP.

MS21042L4

Nut

Purchased No

160 Each 8,067.0000

12 36

Location

Loc Qty

Loc Code

ST300

8067

117441

51

117601

342

118451

133

119017

2541

119075

5000

36x

NAS1149D0463J

Washer

Purchased No

160 Each 7,006.0000

24 72 12-01-06.

Location

Loc Qty

Loc Code

ST298

7006

116025

16

116805

0

117291

1

117460

2

118179

42

118384

178

118612

3

119042

11

119075

6584

119097

169

72x

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Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

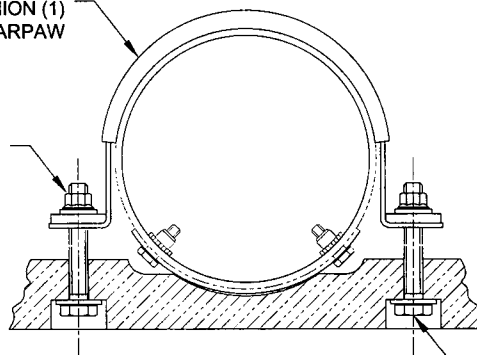
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

REFERENCE ONLY

D2438 CLAMP (1)
D2182B050 RUBBER CUSHION (1)
3 PL PER BEARPAW

MS21042L4 NUT (1)
AN960JD416 WASHER (1)
D2274 RADIUS BLOCK (1)
D2529 WASHER (1)
AN4-17A BOLT (1)
6 PL PER BEARPAW



ADDITIONAL AN960JD416 WASHERS MAY BE INSTALLED UNDER THE NUTS TO ENSURE 1.5-4 THREADS IN SAFETY ON THE BOLTS. ALTHOUGH NOT GENERALLY NECESSARY, IT IS ALSO ACCEPTABLE TO REPLACE THE AN4 BOLTS PROVIDED WITH LONGER OR SHORTER AN4 BOLTS, IF REQUIRED.

Section A-A
Figure 4 – Clamping Detail

5.0 PARTS LIST

Qty -011	Qty -021	Part Number	Description
X		D350-578-011	BEARPAW INSTALLATION
	X	D350-578-021	BEARPAW INSTALLATION
6	6	D2182B050	Rubber Cushion
12	12	D2274	Radius Block
12	12	D2529	Washer
6	6	D2438	Clamp
2		D2432F	Bearpaw
	2	D2672F	Bearpaw
12	12	AN4-17A	Bolt
24	24	AN960JD416	Washer
12	12	MS21042L4	Nut (or MS21042-4)